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010 322

C3-C

Job Sheet 195658



Part No: C3-C

Job Qty: 1 pcs

Part Name: Single Cage



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/29/19

Job Tracking No:

Due Date: 6/7/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3-C Rev G IPP Rev A 18.03.28 New issue DP Verify DD/IPP Rev. B 19.04.25 drawing revision DP
Verify DD/IPP Rev. C 19.05.03 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	External Load - 1	1 pcs	6/7/19		0.00	0.50	External Load - 1		AP
							External Load - 2		
							External Load - 3		
100	External Load - 2 - B4B	1 pcs	6/7/19		0.00	0.50	External Load - 1 - B4B		Michel 2019/6/12
							External Load - 2 - B4B		
							External Load - 3 - B4B		
120	QC 5	1 pcs	6/7/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
140	Packaging 3-1 - Stock - B4B	1 pcs	6/7/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 30 JUN 13 2019 9:59
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



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Container No: S189657



Part: C3-C

Job No: 195658

Serial No/Batch: S189657

Revision: G

Inspector:

Exp Date:

Instructions:

Date: 06/12/19

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				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160	QC 21 - FG	1 pcs	6/7/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - FG - 53

Part Op 90 - Issue S/N.

Descriptions: **100** - 1-Assemble as per drawing. See note 8,9,10 and 11. ***SPREAD COTTER PIN JUST ENOUGH SO THAT IT WILL NOT FALL OUT*** 2-Ink stamp T/N and S/N as per drawing sheet 2 note 12.

120 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg & Stock Location:_____)

160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN6-17A	Bolt	2 Ea (2 ea)	90-External Load - 1	5104372
GA054 90157A112	Steel Cad Plated Cotter Pin 1/8" Dia X 1-1/4" Long	1 Ea (1 ea)	100-External Load - 2 - B4B	5183131
GA059 92562A358	Cad Plated Steel Socket Head Screw 3/8"-16 X 2" Long	1 Ea (1 ea)	100-External Load - 2 - B4B	5185532
WAP? 56 94191A350	Hex Nut 3/8-24 - Steel → MS21044J6	2 Ea (2 ea)	100-External Load - 2 - B4B	5185545 5181732
040 97135A230	3/8-16 Nylock Nut	1 Ea (1 ea)	100-External Load - 2 - B4B	5177910
040 98023A031	Yellow Zinc Plated Grade 8 Steel Washer 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.	1 Ea (1 ea)	100-External Load - 2 - B4B	5157242
201 AN10-22A	Bolt	1 Ea (1 ea)	100-External Load - 2 - B4B	5182082 5172917
198 AN310-10	Castellated Nut	1 Ea (1 ea)	100-External Load - 2 - B4B	5061118
AN310-10	Castellated Nut	1 Ea (1 ea)	100-External Load - 2 - B4B	
160 C3-C-1	Weldment C3 Cage	1 pcs (1 ea)	100-External Load - 2 - B4B	5180957
192 C3-C-8	Lifting Bushing	1 pcs (1 ea)	100-External Load - 2 - B4B	5180893
192 C3-C-9	Bumper	1 pcs (1 ea)	100-External Load - 2 - B4B	5182341
NAS1149F0663P	Washer	4 Ea (4 ea)	100-External Load - 2 - B4B	5166716
NAS1149F1032P	Flat Washer, National Aeronautical Standard	2 Ea (2 ea)	100-External Load - 2 - B4B	5173079
WAP? NAS1149F0663R	WASHER	1		5076016-1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-External Load - 1	AN6-17A	2	39	0
100-External Load - 2 - B4B	90157A112	1	101	0
	92562A358	1	5	0
	94191A350	2	10	0
	97135A230	1	20	0
	98023A031	1	69	0
	AN10-22A	1	12	0
	AN310-10	2	29	0
	C3-C-1	1	0	0
	C3-C-8	1	16	0
	C3-C-9	1	13	0
	NAS1149F0663P	4	514	0
	NAS1149F1032P	2	93	0

Part Specifications

Specifications could not be found.

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Saf-T-eye (M138973)
Aerosell grease NO.7 (S138964)

GA201

Entered: _____ Date: _____



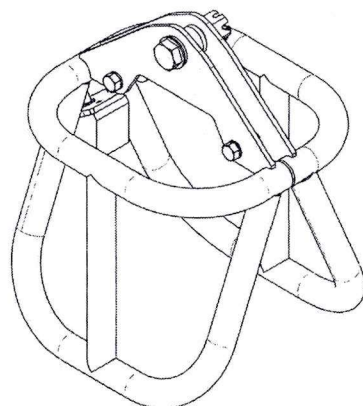
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

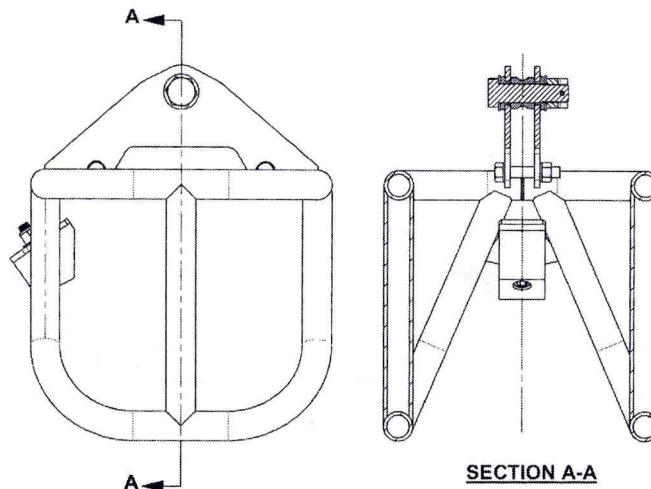
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

ITEM #	QTY	PART #	PART TITLE
-1	1	C3-C-1	WELDMENT C3 CAGE
-8	1	C3-C-8	LIFTING BUSHING
-9	1	C3-C-9	BUMPER
-10	2	C3-C-10	McMaster#94191A350 OR EQUIV (CAD PLATE GRADE 8 STEEL HEX NUT 3/8"-24)
-11	1	C3-C-11	McMaster#90157A112 OR EQUIV (STEEL CAD PLATED COTTER PIN 1/8" DIA. X 1-1/4" LG.)
-12	1	C3-C-12	McMaster#92562A358 OR EQUIV (CAD PLATED STEEL SOCKET HEAD SCREW 3/8"-16 X 2" LG.)
-13	1	C3-C-13	McMaster#98023A031 OR EQUIV. (YELLOW ZINC PLATED GRADE 8 STEEL WASHER 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.)
-14	1	C3-C-14	McMaster#97135A230 OR EQUIV. (ZINC YELLOW PLATED GRADE 8 STEEL NYLON INSERT LOCKNUT 3/8"-16)
15	2	AN6-17A	CAD PLATE STEEL HEX BOLT 3/8"-24 X 1.953" LG.
16	1	AN10-22	CAD PLATE STEEL HEX HEAD 5/8"-18 X 2.391" LG.
17	1	AN310-10	CAD PLATE STEEL CASTLE NUT 5/8"-18
18	2	NAS1149F1032P	STEEL WASHER 0.640" ID. X 1.188 OD. X 0.065" THK.
19	4	NAS1149F0663P	STEEL WASHER 0.390" ID. X 0.625" OD. X 0.063" THK.



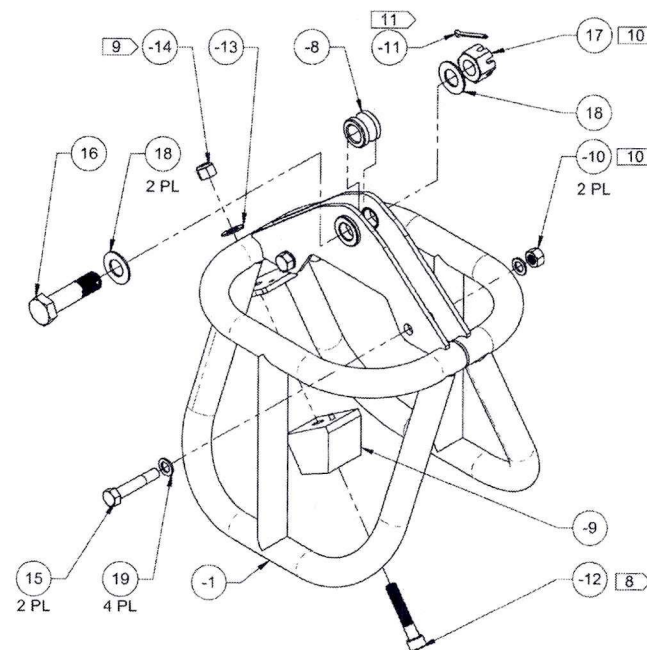
C3-C C3 CAGE



SECTION A-A

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM -12 THEN ASSEMBLE WITH ITEM -14, AND REMOVE EXCESS
- 9) TORQUE ITEM -14 TO 20-28 FT-LBS
- 10) INSTALL ITEM -10 AND ITEM 17 HAND TIGHT
- 11) DO NOT FOLD COTTER PIN



G	FOR PREVIOUS REV'S SEE OLD PDFs PIN ATTRIBUTED TO ALL McMaster# TO MATCH THE MANUAL	19-718	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA C3-C C3 CAGE COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	VM		
CHECKED	MBB		
MFG. APPR.	DD		
APPROVED	WY	TOOL PART #	REV. G
DATE	2019-06-03	TITLE	SHEET 1 OF 10
		SCALE	NTS